

5/12

w/o SPLIT

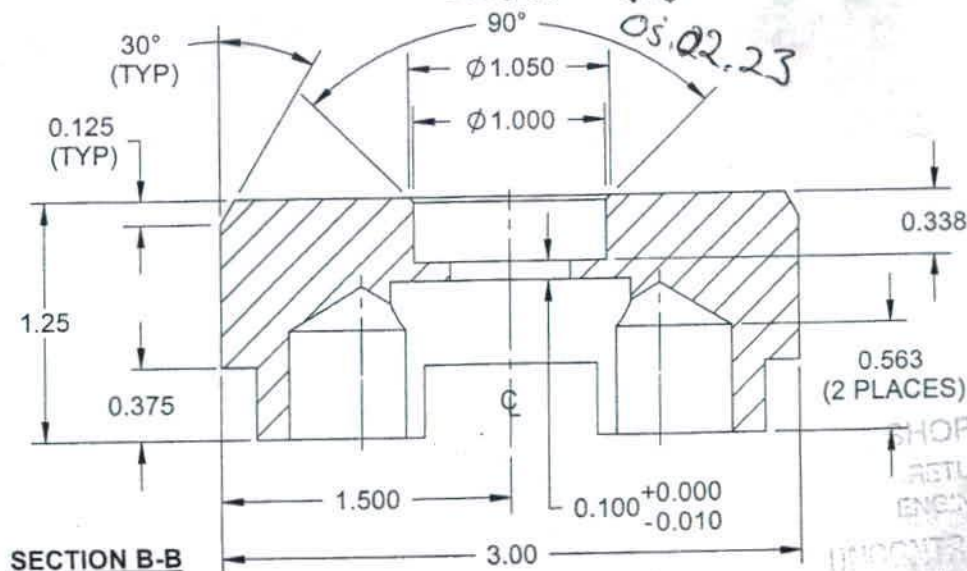
DART AEROSPACE LTD	Work Order:	22479B
Description: Battery Lock Casing	Part Number:	D3393-1
Dwg: D3393 Rev. A page 2	Qty:	100 88 18
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	OK	05.02.21	100
2	MV	Cut blank: 1.500" x 1.500" x 3.125" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.500) Identify for D3393-1 Batch: M16954 M10415	SD	05.02.23	18
3	MV	Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1	SD	05.02.23	18
4	QC2	Inspect parts as they come off the CNC machine	SD	05.02.23	18
5	QC8	Second check	mk	05/03/03	18
6	MV	Deburr <u>Tumble</u>	SD	05.02.23	18
7	QC5	Inspect work to Step 6	ml	05.03.03	18
8	FP	Chemical Conversion Coat as per QSI 005 4.1	mm	5.G. 05.03.03	18
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	ml	05.03.03	18
10	QC3	Inspect Powder Coat	2	05.03.04	18
11	ST	Identify and Stock	2	05.03.04	18
12	AC	Cost / part <u>21.92</u>	5 uc	05.03.08	18
13	DC	Close W/O <u>16.97</u> Inspect Level 21	OK	05.03.09	18

Rev	Date	Change	Revised By	Approved
A	05.02.18	New issue	KJ/JLM	

RELEASED
05.02.18

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

WORK ORDER
NO. 22479

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DART AEROSPACE LTD		Work Order: 22779 B
Description:		Part Number: 03393-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .730	±.010	.734	✓			
.625	±.000	.631	✓			
Ø 1.250	±.010	1.248	✓			
1.088		1.089	✓			
Ø .734		.735	✓			
2.658		2.657	✓			
.125.45°		.128x45°	✓			
→ 1.850		1.550	✓			Good!
.775						Cannot measure
1.50		1.490	✓			
.750		.740	✓			
90°		90°	✓			
Ø 1.050		1.050	✓			
Ø 1.000		.991	✓			
.338		.342	✓			
.563		.571	✓			
.100	±.000	.101	✓			
3.00	±.010	3.002	✓			
1.500		1.500	✓			
.375		.382	✓			
1.25		1.255	✓			
.125x30°		.135x30	✓			

Measured by: SD	Audited by: JML	Prototype Approval: N/A
Date: 030302	Date: 05/03/02	Date:

Rev: A	Date:	Change: New Issue	Revised by: KJ/JLM	Approved:
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